0, /,	70815	PM										Page 1
Could be seen as a seen	/35-35 Vearshoe			Accept					Setup	Start Stop		
Start Da. 66 Required Date: 66 Reference:		Qty: 12.00 l Qty: 12.00			Cust Item I Customer:	D:						
	Process Plan:	P	Date://06-/5	Tooling: _ SPC (Y/N):		nte:)	Run	Start Stop		
Sequence ID/ Work Center ID Draw Nbr	Opera Descri Revision N	ption		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
D3535	Rev B	Dr		0.00								
Waterjet FLOW CNC Waterjet	FLOW '	WATER JET Memo 1-Cut as per Deburr if ne	Dwg D3535 □Dwg Rev cessary	0.00	□2-			Bu	<u>- 7-4</u>	,		<u>3</u>
110 	QC2- In	nspect parts off m	achine FAI/FAIB	0.00				<u> B1(-</u>	7-4	t	·	
120 QC Quality Control	QC8- Ir	nspect parts - sec	and check	0.00 0.00	7104			(x12)) -			

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Dart	Aeros	pace	Ltd
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W/O:			WORK ORDER CHANGES						
DATE :	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	App QC Inspe
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						····			<u>.</u>
Part No:		PAR #:							
	Re	solution:						Date: _	
NCR:		V	ORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial	Action Description	ction B Sign	& Sec	cation	Approval Chief Eng	Appro QC Inspe
		4.444	Chief Eng	Chief Eng	Date	9	· - · · · · · · · · · · · · · · · · · ·	-	
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	:								

Work Order ID 70815

Wednesday, June 15, 2011 2:26:37 PM



Page 2

Item ID:

D3535-35

Accept



Setup Start



Revision ID:

Start Date:

Item Name: Wearshoe

Required Date: 6/22/2011

6/15/2011

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Date:

Run

Start

Stop

Stop



QC:

Date:

SPC (Y/N):

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

5 2

Reject Insp. Number Stamp

Sequence ID/

Work Center ID

130

Brake NC

Brake NC

Operation Description

NC BRAKE

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

1-Deburr if necessary ☐ 2-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326. □3-Identify as D3535-35.

5B 1167/05

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

000 8 Woster

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo OFINISH TIME: START TIME:

M112197

W/O:	_		WO	RK ORDER CHANGES	S				
DATE	STEP	PRO	CEDURE CHAN	· · · · · · · · · · · · · · · · · · ·	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		· 							
Part No	:	PAR #:	Fault Categ	Jory:	NCR: Yes	No DQ	A:	Date: _	
		esolution:							
NCR:			NORK ORDE	R NON-CONFORMAN	ICE (NCR	i)			
DATE	STEP	Description of NC	Description of NC Corrective Action Section B			Verification Appro		Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		tion C	Chief Eng	QC Inspector
		·							
							•		
							,		

Work Order ID 70815



Page 3

Wednesday, June 15, 2011 2:26:37 PM

Item ID:

D3535-35

Accept



Setup Start



Stop



Revision ID: Item Name:

Wearshoe

Required Date: 6/22/2011

6/15/2011

Start Oty: 12.00 Req'd Qty: 12.00

Cust Item ID: Customer:

Tool ID

Reference:

Start Date:

Approvals:

Process Plan:

Date: ____

Tooling:

Date:

Run Start



Date: SPC (Y/N):

Date:

Tool # Plan

Code

Stop



Sequence ID/ **Work Center ID**

160

QC3- Inspect Part Finish

Operation

Description

0.00

Set Up/

Run Hours

0.00

Qty Qty

Accept

Reject Reject Number Stamp

Insp.

Quality Control

Identify as per dwg & Stock Location:

Memo

Memo

0.00

12 0 AL11-76.

Packaging

180

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			· · · · · · · · · · · · · · · · · · ·						
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Ye	s No DO	QA:	Date: _	<u> </u>
		esolution:							
NCR:			WORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sigr	ı& ∣ _{Se}	fication ction C	Approval Chief Eng	Approval QC Inspector
		·				:			

Picklist Print

Wednesday, June 15, 2011 2:26:43 PM

Work Order ID: 70815

Parent Item:

D3535-35

Parent Item Name: Wearshoe



Start Date: 6/15/2011

Required Date: 6/22/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	236.6630		10.1330	5	4	
										വഥ	7-4		

304/316 .040 Sheet

Location	Loc Qty	Loc Code	
MAT020	236.663		
116623	0.2		
117550	9.363		
117933	227.1		117933

	Johnso							•	
W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvai QC Inspector
									
									·
Part No	:	PAR #:	Fault Cat	tegory:	NCR: Yes	No DQA	\:	_ Date: _	
	R	esolution:	Dispositi	ion:	QA: N/C Clo	sed:		Date: _	
NCR:			VORK ORI	DER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		n B	Verification			Approval	
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sectio	n C	Approval Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	70815
Description: Wearshoe	Part Number:	D3535-35
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension	<u> </u>			
2.000	+/-0.010	2.000	\		V BOZ	
1.885	+/-0.010	1,886	4		V	
6.00	+/-0.030	6.00	7		T 1301	
6.75	+/-0.030	6.75	8		7	
Ø0.188	+0.005/-0.001	, 193	7		V	
23.250	+/-0.010	23.756	K		7	
19.750	+/-0.010	19,750	4		T	
17.750	+/-0.010	17.750	8		7	
14.250	+/-0.010	14.750	X.		7	
9.500	+/-0.010	9,500	8		7	
4.750	+/-0.010	4,750	×		7	
0.300	+/-0.010	306	7		V	
0.300	+/-0.010	.305	D		V	
0.038	+/-0.010	,037	8	•	V	
					V	
		-				

Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	11-7-4	Date: World	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.05.10	New Issue	KJ/JLM 🖟	E

W/O:			W	ORK ORDER CHANGE	S						
DATE STEP PROCEDURE CH			ANGE	Ву			Approval Chief Eng / Prod Mgr	Approval QC Inspector			
						•		1			
			100								
								1			
Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes No DQA:				Date:		
	R	esolution:	Dispositi	on:	QA: N/C Closed:			Date:			
NCR:	- 4-00	V	VORK ORI	DER NON-CONFORMA	NCE (NCR)					
DATE	STEP	Description of NC		n B	Verification		Approval	Approval			
DAIE SI	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector		
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USA,

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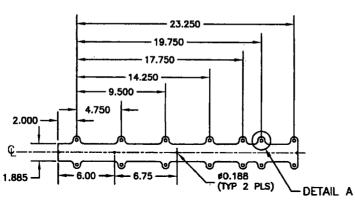
D3535 DRAWING NO

WEARSHOE

DATE 07.04.17

RELEASE

72.75



SHOP COPY RETURN TO ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER

D3535-35F FLAT PATTERN

C-D3535-35 BEND DETAIL

> 30.750 27.250 22.500 17.750 14.250 2.000 16.00 DETAIL A 21.00 **¢**0.188 D3535-37F FLAT PATTERN (TYP 4 PLS)

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3 3) PART IS SYMMETRICAL ABOUT &
4) TOLERANCES ARE PER DART QSI 018 UNLESS

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DOCUMENT

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OR COMMUNICATED TO ANY OTHER PERSON W

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NOT TO BE USED FOR ANY NOT TO BE USED FOR ANY NET AEROSPACE USA INC.

PURPOSE

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COPIED

- OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



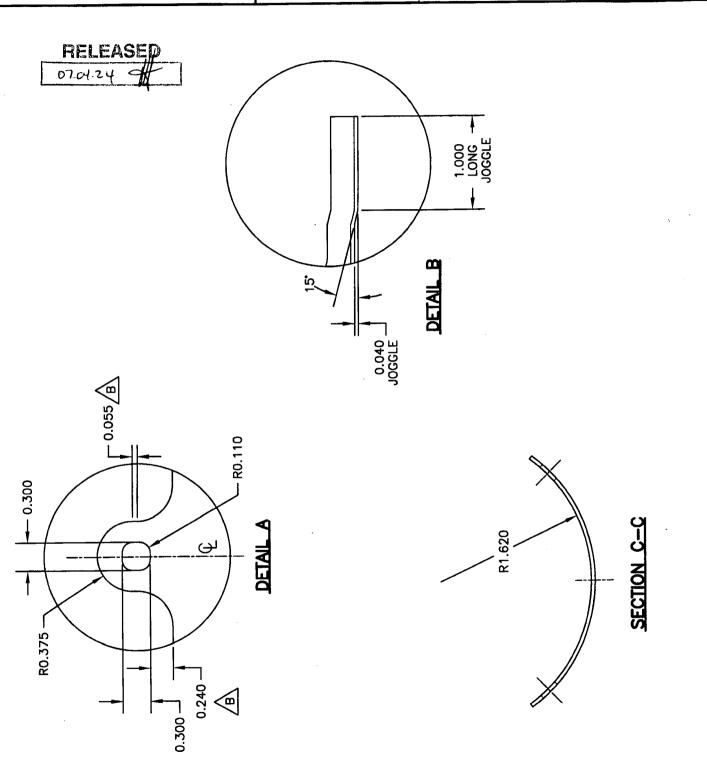
W/O:		•	W	ORK ORDER CHANGES					
DATE	STEP	PRO	OCEDURE CH	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
		•							

Part No	•	PAR #:	Fault Cat	gory: N	ICR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Dispositi	n: (A: N/C C	closed:	· · · · · · · · · · · · · · · · · · ·	Date: _	
NCR:			WORK ORI	ER NON-CONFORMANO	CE (NC	R)			
DATE	OTED	Description of NC			Verification		Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	n & Section C	Chief Eng	QC Inspector	

NCR:		WOME ONDER NOW-OUND IMMANUE (NOM)								
		Description of NC	Corrective Action Section B			Verification	Approval	Ammanal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
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DESIGN	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKED	APPROVED ,,/	DRAWING NO.	REV. B
		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:1



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